



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Order 726 DEC 12
RBW6705G02031-3G

Job Sheet 168807



Part No: RBW6705G02031-3G

Job Qty: 1 ea

Part Name: Rigging Pin Assembly N1



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 12/8/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6705G02031-3G Rev2 IPP Rev.A New issue 17/11/07 JFS Verified by:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/17	0.00	0.00	Start Up Machining		ML
100	Small Fab	1 pcs		12/7/17	0.00	0.33	Small Fab-9		MLC / S.C.L.
110	QC	1 pcs		12/7/17	0.00	0.00	QC5		38
120	Outsource	1 pcs		12/7/17	0.00	0.00	Outsource1		MLC
130	Outsource	1 pcs		12/7/17	0.00	0.00	Outsource13		MLC
140	Packaging	1 pcs		12/7/17	0.00	0.00	Packaging2		MLC 18/02/01
150	QC	1 pcs		12/7/17	0.00	0.00	QC6		38
160	Small Fab	1 pcs		12/8/17	0.00	0.17	Small Fab		ML 3-89
170	QC	1 pcs		12/8/17	0.00	0.00	QC5		GA
190	Packaging	1 pcs		12/8/17	0.00	0.00	Packaging3		GA FEB 05 2018
200	QC21-SA	1 Ea		12/8/17	0.00	0.00	QC21		21 FEB 05 2018

Part Op 100 - 1- Bend as per dwg. 2- Cut rod to Finished length and drill hole as per dwg. 3- Grind chamfer on both end.
Descriptions: 120 - 1--Issue P/O to Metcore ; P/O _____ RC: 26-30 2-Bead blast 3- Certificate of Conformity is required
NOTE DROP SHIP TO FINISHER To ship directly to Groupe Altech
130 - -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required
140 - C of C is required.
160 - - Install lanyard as per dwg.
170 - Black ink stamp T/N on flag to fit as per DWG.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	8893K178 5316496	0	0	0	0
160-Small Fab	3896T31	2	32	0	0
	CL-2-C	1	41	0	0
	NAS1756-12	1	91	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

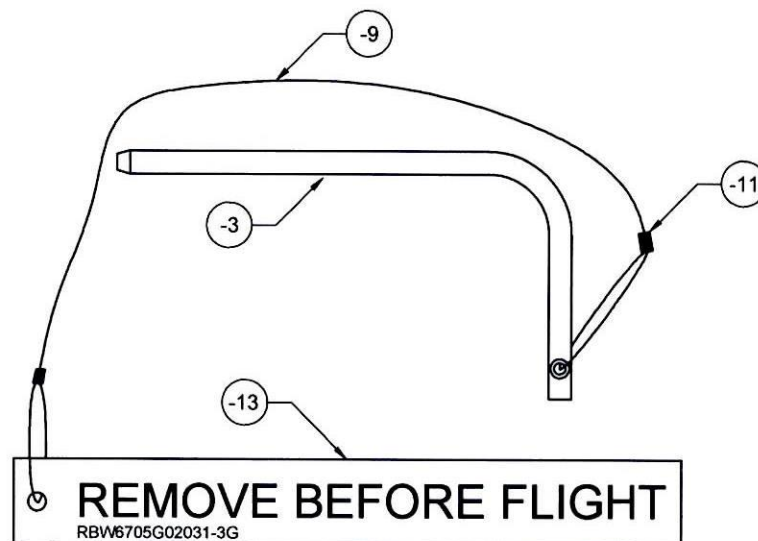
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																							
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																					
Description Work Order Deviation				Completed By																																																					
Start up Operation Job No: 168807 Mfg Date: 12/15/17 RBW6705G02031 - 3G Rigging Pin Assembly N1 Barcode Part NO: S022771 Revision: 1 Operation: 1 Change No: 1 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com				Lead hand / Supervisor Approval Verification																																																					
				QC / QA Coordinator Approval																																																					
				Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence																																																					
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td>Environment</td><td>☐</td> <td>No Re-verification</td><td>☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operator</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> </tbody> </table>						Root Cause				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐
Root Cause																																																									
Environment	☐	No Re-verification	☐																																																						
Design	☐	Operator	☐																																																						
Doc/Data	☐	Offset/Setup	☐																																																						
Equip/Tooling	☐	Supplier	☐																																																						
Handling/Pre	☐	Training	☐																																																						
Material	☐	Use for Testing	☐																																																						
Internal Transport	☐	Poor Information	☐																																																						
Tribal Knowledge	☐	Rushing	☐																																																						
LOA	☐	Product Improvement	☐																																																						
Substation	☐	Process Improvement	☐																																																						
Past Expiry Date	☐	Manufacturing Process	☐																																																						
Misidentified	☐	Past Due	☐																																																						
OTHER : _____																																																									

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	DELETED -1 WELDMENT, -5 AND -7, EXTENDED PIN SHORT END FROM 1.62 TO 2.040, ADDED Ø.094 HOLE FOR LANYARD.	8/29/12	RJC	SE
2	-3 CH'D BEND RADIUS WAS R .56 IS R .50.	2/12/13	BIM	GE

TEO ATTACHED



RBW6705G02031-3G

BLACK INK STAMP TOOL No. ON FLAG TO FIT.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168807 MJS
1711-23

NOTES

- PART OF KIT RBW6705G00131-3G.
- QUANTITY 1 PER KIT.

ASSY #	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-3	1	PIN N°1	O-1	Ø3/16 x 5-1/2 MCMaster-CARR #8893K27	2
		B/O	-9	1	LANYARD WIRE	COATED STEEL	Ø1/16 x 10 REID #CL2C	1
		B/O	-11	2	FERRULE	ALUMINUM	Ø1/16 x 3/8 MCMaster-CARR #3896T31	1
		B/O	-13	1	REMOVE BEFORE FLIGHT FLAG	COATED CLOTH	NAS1756-12 AIRCRAFT HARDWARE	1

RED BARN MACHINE	
TITLE RIGGING PIN ASSY. N° 1	
DWG NO. RBW6705G02031-3G	REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PIR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-28-10
SHEET 1 of 2	
DRAWN BY: PERRITT APPROVED: <i>D. Wed</i> HEAT TREAT FINISH SPEC USED ON MODEL AGUSTA	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
This space is reserved for the description of the work order deviation.				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

**ENGINEERING ORDER # TEO17-653**

SCALE: NTS

SHEET 1 OF 1

DRAWING NO. RBW6705G02031-3G

REV: 2

EFF.: NEXT ORDER

CHANGE CATEGORY

TITLE: RIGGING PIN ASSY #1

☐ MAJOR ☒ MINOR

DATE 17.09.13

APPROVED: WM 10/09/2017 

MFG. APPR.: DP 09/26/2017

CHECKED: SAC 09/25/2017

DRAWN: VM 09/25/2017

TRANSACTION CODE (TC):

A-ADD C-CREATE
R-REVISE D-DELETE

REASON: WRONG PURCHASE #

COPYRIGHT © 2017 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

WAS : RBW6705G02031-3G-3 REV 2 PURCHASE # McMaster#8893K27

IS : RBW6705G02031-3G-3 REV 2 PURCHASE # McMaster#8893K178

DOCUMENTS EFFECTED: ☐ PATTERN ☐ INSTALL INSTRUCTIONS ☒ BOM

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038769**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038769

PO Date: 1/12/18

Due Date: 1/23/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
JAN 15 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments: PARTS SHIP FROM METCOR FROM
PO:038630 & PO038680

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	168814	RBW6705G02331-3G	Rigging Pin Assembly N4 -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	1/23/18	1 pcs	0 pcs	1 pcs	\$12.857142/pcs	\$12.86
2	168918	RB500N9505-1M-1	Socket -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	1/23/18	1 pcs	0 pcs	1 pcs	\$120.00/pcs	\$120.00
3	168807	RBW6705G02031-3G	Rigging Pin Assembly N1 -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	1/23/18	1 pcs	0 pcs	1 pcs	\$12.857142/pcs	\$12.86
4	168813	RBW6705G02231-3G	Rigging Pin Assembly N3 -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	1/23/18	2 pcs	0 pcs	2 pcs	\$12.857142/pcs	\$25.71
5	168809	RBW6705G02131-3G	Rigging Pin Assembly N2 -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	1/23/18	3 pcs	0 pcs	3 pcs	\$12.857142/pcs	\$38.57

Grand Total: \$210.00



Certificat de Conformité / Certificate of Compliance

(005774-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

005774- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
22-Jan-2018		Curtis Anderson		38769				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap	À venir/ Back Order
1	RBW6705G02331-3G Rev.	RBW6705G02331-3G ZINC CLEAR ASTM B633 TYPE 1, SC2 C OF C REQUIRED	ZINC CH	1	1	0	0	0
2	RB500N9505-1M-1 Rev.	RB500N9505-1M-1 BLACK OXIDE MIL-C-13924C, CLASS 1 C OF C REQUIRED	BLACK-OXIDE CH	1	1	0	0	0
3	RBW6705G02031-3G Rev.	RBW6705G02031-3G ZINC CLEAR ASTM B633, TYPE 1, SC 2 C OF C REQUIRED	ZINC CH	1	1	0	0	0
4	RBW6705G02231-3G Rev.	RBW6705G02231-3G ZINC-CLEAR ASTM B633, TYPE 1, SC2 C OF C REQUIRED	ZINC CH	2	2	0	0	0
5	RBW6705G02131-3G Rev.	RBW6705G02131-3G ZINC-CLEAR ASTM B633, TYPE 1, SC2 C OF C REQUIRED	ZINC CH	3	3	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.